



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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D212-664-201TRN
Job Sheet 198234



Part No: D212-664-201TRN **Job Qty:** 1 pcs

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs **Status:** New **Priority:** Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 8/7/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D212-664-241 REV E IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 Removed polish EC verified DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time			
100	Mori Seiki TL-40 - 1	1 pcs		8/7/19	1.00	1.33	Mori Seiki TL-40 - 1				
110	QC 2	1 pcs		8/7/19	0.00	0.00	QC 2 - 1			662019-08-01	9-89
							QC 2 - 12				
							QC 2 - 14				
							QC 2 - 17				
							QC 2 - 19				
							QC 2 - 2				
							QC 2 - 20				
							QC 2 - 22				
							QC 2 - 23				
							QC 2 - 25				
							QC 2 - 32				
							QC 2 - 33				
							QC 2 - 35				
							QC 2 - 39				
							QC 2 - 4				
							QC 2 - 40				
							QC 2 - 44				
							QC 2 - 45				
							QC 2 - 48				
							QC 2 - 49				
							QC 2 - 50				
							QC 2 - 51				
							QC 2 - 52				
							QC 2 - 57				
							QC 2 - 62				
							QC 2 - 63				
							QC 2 - 8			DAS	
							QC 2 - 66			662019-08-01	
							QC 2 - 64			9-89	

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120	Mori Seiki TL-40 - 1 - B4B	1 pcs	8/7/19	1.00 1.33	Mori Seiki TL-40 - 1 - B4B
130	QC 2	1 pcs	8/7/19	0.00 0.00	QC 2 - 1
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	

DAS
662019-08-07
9-89

DAS
662019-08-07
9-89

BB/GP 19-08-20

				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Crosstubes - 1 - B4B	
145 Crosstubes - 2 - B4B	1 pcs	8/7/19	0.00 0.25	Crosstubes - 2 - B4B	BB 8/20/2019
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
				Crosstubes - Bend - B4B	BBB 19-08-20
150 Crosstubes - Bend - 2 - B4B	1 pcs	8/7/19	0.50 0.25	Crosstubes - Bend - B4B	
160 QC 7	1 pcs	8/7/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	TW 19-08-21
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	8/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	ISB 8/27/2019
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	8/7/19	0.00 0.00		QC 21 - SA - 21	AUG 27 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Fill tube with sand & install plugs DT8534 on both ends as per Descriptions: Folio FA114 2-Turn first side as per Folio FA114
110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Turn second side as per Folio FA114
130 - (QC2- Inspect parts off machine FAI/FAIB)
140 - (QC8- Inspect parts - second check)
145 - (Crosstubes) GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
150 - Crosstubes) 1- handfinish X-TUBE INSIDE AND OUT
160 - (QC7-Inspect Chemical Conversion Coat)
170 - (Identify as per dwg & Stock Location:) Identify and stock in kanban rack Location:
180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6006-129	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	F123967

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6006-129	1	53	0

Part Specifications				
Specifications could not be found.				

Plex 7/24/19 8:40 AM Dart.lajeunesse.marie



Container No: S202374



Part: D212-664-201TRN

Job No: 198234

Serial No/Batch: S202374

Revision: E

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

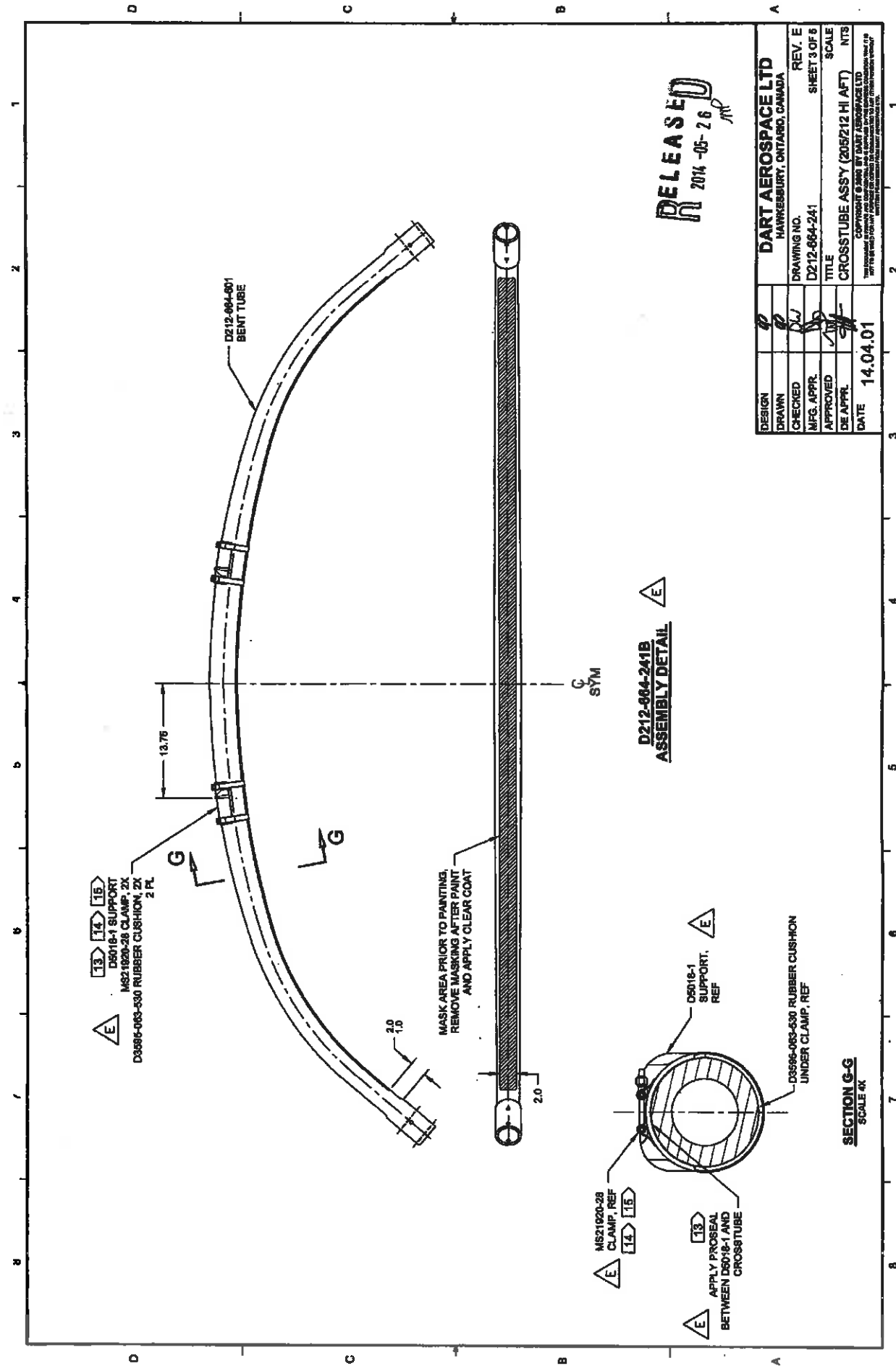
CANADA

TEL: 1 813 632-6200

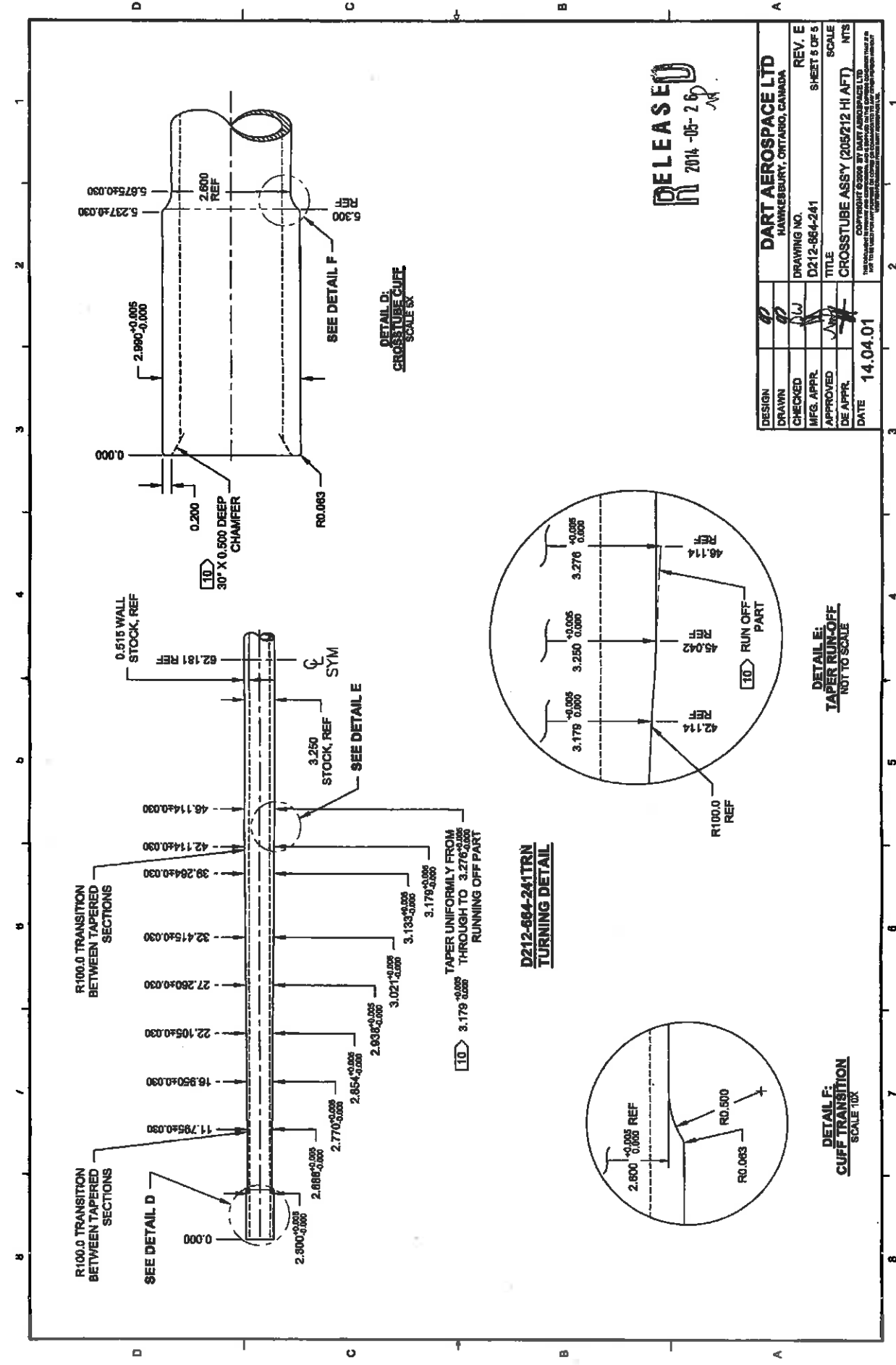
Email: sales@dartaero.com

www.dartaerospace.com

Date: 08/01/19



RELEASED
2014-05-26



RELEASED
2014-05-26

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DART AEROSPACE LTD	Work Order:	198734
Description: Crosstube Assembly (205/212 High Aft)	Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.204	✓	CNC-08	
	R0.063	+/-0.010	.063	✓	RG	
	2.990	+0.005/-0.000	2.995	✓	CNC-04	
	5.237	+/-0.030	5.241	✓	CNC-08	
	2.600	+0.005/-0.000	2.605	✓	CNC-04	
	2.686	+0.005/-0.000	2.691	✓		
	2.770	+0.005/-0.000	2.775	✓		
	2.854	+0.005/-0.000	2.859	✓		
	2.938	+0.005/-0.000	2.943	✓		
	3.021	+0.005/-0.000	3.026	✓	CNC-05	
	3.133	+0.005/-0.000	3.138	✓	"	
	3.179	+0.005/-0.000	3.184	✓	"	
SIDE B	0.200	+/-0.010	.203	✓	CNC-08	
	R0.063	+/-0.010	.063	✓	RG	
	2.990	+0.005/-0.000	2.994	✓	CNC-04	
	5.237	+/-0.030	5.245	✓	CNC-08	
	2.600	+0.005/-0.000	2.605	✓	CNC-04	
	2.686	+0.005/-0.000	2.691	✓		
	2.770	+0.005/-0.000	2.775	✓		
	2.854	+0.005/-0.000	2.859	✓		
	2.938	+0.005/-0.000	2.943	✓		
	3.021	+0.005/-0.000	3.025	✓	CNC-05	
	3.133	+0.005/-0.000	3.138	✓	"	
	3.179	+0.005/-0.000	3.184	✓	"	
	124.362	+/-0.020	124.36	✓	Tape	



Job: _____		DISPOSITION			DEPARTMENT/PROCESS										
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				
Date :	Sequence #:	QTY Affected :		MRB (QS1042)											
Description Work Order Deviation				Disposition											
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY											
				Pressure/Forced			Contamination			Power Loss/ Surge			Positioned Wrong		
				Bending			Misaligned/off center			Folio/Program			Outside Tolerance		
				Crushing			BOM/Route			Grain Direction			Drawing		
Cracks			Broken/Damage/Defect			Weld			Finish						
Crimp/kink/Ripple/Wave/Twist			Incomplete/Unclear Instructions			Wrong Stock Pulled			Part Lost/Missing						
Marks/Chatter			Drill Holes			Out of Sequence			Misread						
Mislabeled			Fit/Function			Off-set/Set-up									
Other/Details:															
				Completed By											
				Lead hand / Supervisor											
				QC / QA Coordinator											